

Date: Wednesday, 1/11/2006 4:25:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT BRACKET		
Job Number	: 25451					
Estimate Number	: 10260					
P.O. Number	: N/A			Part Number	: D23623	
This Issue	: 1/11/2006		S.O. No. : N/A	Drawing Number	: D2362 REV E1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : MACHINED PARTS	Drawing Revision	: E1	
Previous Run	: 25073			Material	: N/A	
Written By	: SEE COMMENT Below			Due Date	: 1/18/2006	
Checked & Approved By	: SEE COMMENT Below			Qty:	10	
Comment	: Est: G 00.05.18 Added inspection level 8 EC			Um:	Each	

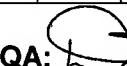
Additional Product

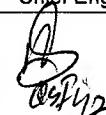
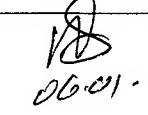
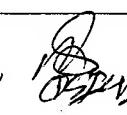
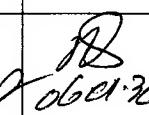
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2265	Step Support Casting	
Comment: Qty.: 1.0000 Each(s)/Unit		Total : 5.0000 Each(s)	
Step Support			
Pick:			
Qty	Part Number	Description	Batch
1	D2265	Step Support	<u>b25401-1</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: Machine per folio D2362-3		SD 06.01.28	9 P70
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: Inspect Level 2			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1		SD 06.01.28	9
Deburr			
6.0	POWDER COATING	POWDER COATING	
Comment: POWDER COATING		DL 06.01.30	9
Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.01.28	2	- part hit by tool ↳ modify program. → done 		Note back in Calio / Program changed	SA 06.01.28	 06.01.28	 06.01.28	 06.01.28

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SUPPORT BRACKET
Job Number: 25451		Part Number: D23623
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>206-01-31</i>
Comment: INSPECT POWDER COAT		
8.0	D23971 	Rubber Cushion 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Rubber Cushion Pick: Qty Part number Description Batch <i>B256585</i> 1 D2397-1 Rubber <i>B254694</i> <i>ml06/01/30</i> 9		
9.0	D23973 	Rubber Cushion 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Rubber Cushion Pick: Qty Part number Description Batch <i>B256605</i> 1 D2397-3 Rubber <i>B254704</i> <i>ml06/01/30</i> 9		
10.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362 Batch <i>M16194</i> <i>ml06/01/30</i> 9		
11.0	QC5 	INSPECT WORK TO CURRENT STEP  <i>206-01-31</i>
Comment: INSPECT WORK TO CURRENT STEP		
12.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>172</i> <i>C206/01/31</i> (9)		
13.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		
Job Completion 		<i>N 0601-31</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

E1 03.10.07 TOLERANCE CHANGE ~~11~~ RT

0.257 X 0.75 SLOT

VIEW A-A

↓ 0.00 C.

REMOVE TIPS
FROM CASTING
MAX 0.080

0.800

CENTER D2397-1/3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1
D2397-3 RUBBER CUSHION (1

The drawing shows a slot component with a width of 0.257 and a height of 0.75. A callout indicates a slot width of 0.257. A fastener detail shows a slot width of 0.257 and a slot height of 0.75. The drawing also includes a reference line labeled 'R' and a callout for a slot width of 0.257.

1.876
↓ 1.88
EI

RELEASE
98-12-14 KE

DAVID
GARRETT

DESIGN	DART AEROSPACE LTD		
BW	HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>RE</i>	<i>WF</i>	D2362	SHEET 1 OF 3
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	

UNDER REVIEW

DEMONSTRATE, BUT CHECK WITH

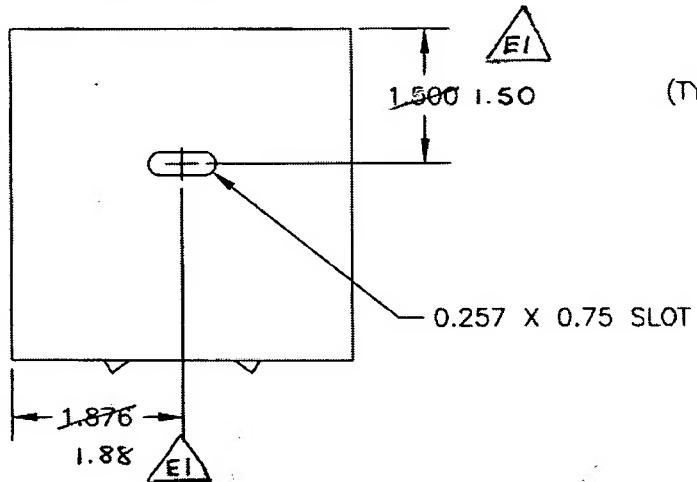
OK if off

NOTES:
MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

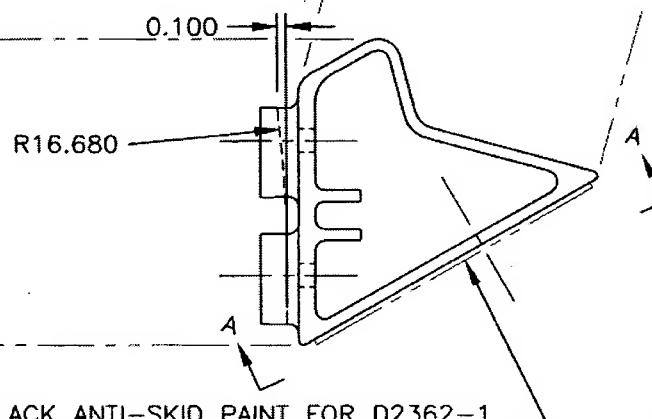
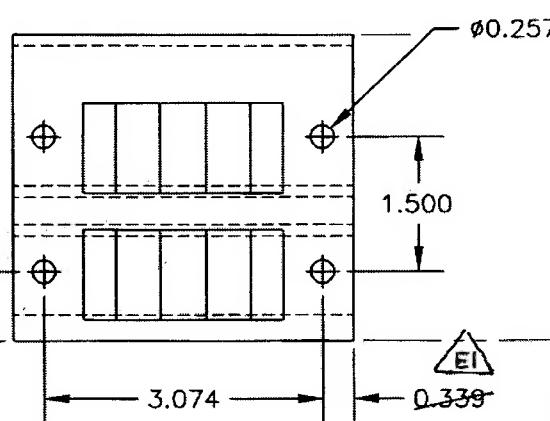
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

OACOPY
0306

DESIGN BW	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>MM</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SHEET 2 OF 3 SCALE 1:2

RELEASED
12-14-98
UNDER REVIEW
01.03.98 CP
DESIGNOK, BUT CHECK W/
D339 BEFORE MANUFACTURE

OK
CP 12-14-98

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

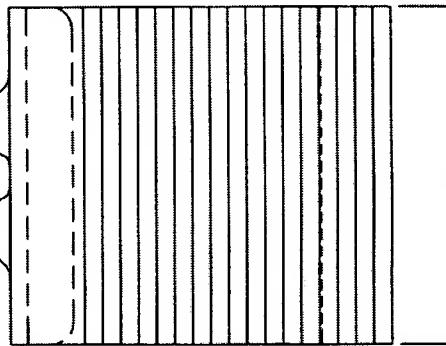
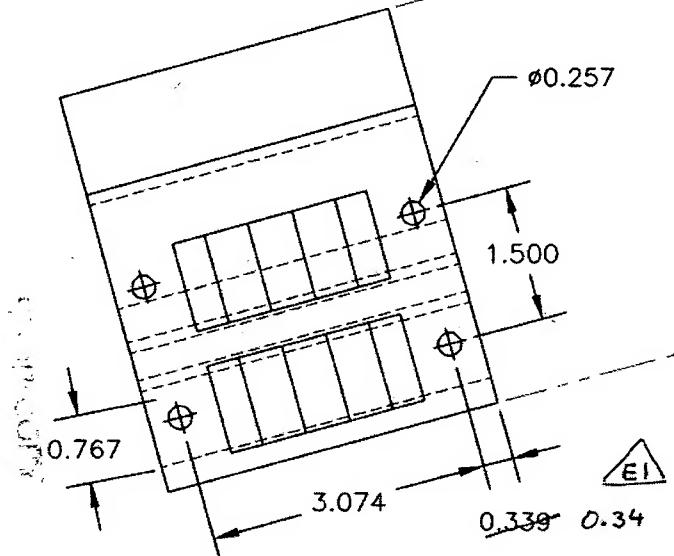
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004



3.750 (REF)

01/03/95 CP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

OK FOR MANUFACTURE

D2362-7

UNDER REVIEW

RELEASED
44-12-14
EG

DESIGN BW	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEKED RE	APPROVED MM	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3 SCALE 1:2



DART AEROSPACE LTD	Work Order:	25451
Description:	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	SD	Audited by:		Prototype Approval:	
Date:	06.01.28	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	